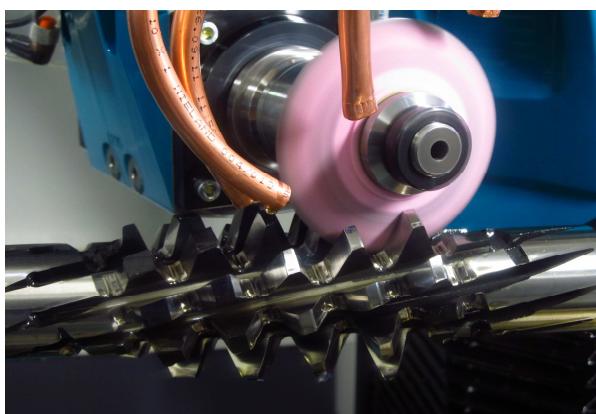
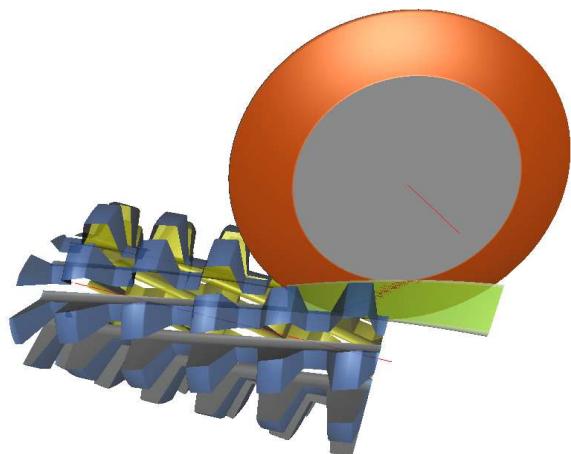


## Worm Gearbox Ø75 Z9

### A12-021

This worm gearbox with gash-lead of 22° and gash depth of 20 mm is resharpened with a dressed wheel, where a dressing takes place each 9th tooth. The calculation of the DXF-form of the wheel as well as the optimized position on the cutting face is fully automatic. The resharpening takes off 0.2 mm in 9 passes and 2 sparkout passes.



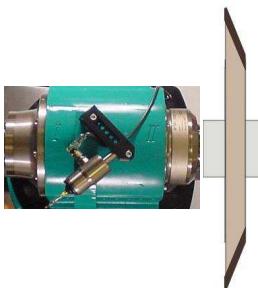
### 1. Cycletime for Resharpening

Workpiece:	Ø 75 mm, L 120 mm, Gash-Lead 582 mm, Mod. 7.5			
Material HSS				
Operations	Probe A Pos	Dress	Gash	Index Check
Feed [mm/Min]	2000	180	800	2000
Power [kW]		1	2	
Cutting speed [m/s]		32	38	
Used wheels				
Grinding time [s]	35	257	1576	120
Total cycle time	33 Min 8			

The cycle times are indicative. Material to be ground, grinding wheels, coolants can influence the cycle times considerably.

### 2. Used Grinding Wheels

1 1V1 Ø95 C120 DXF 20°



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### 3. Machine and Software Requirements

Machines: 5 axes CNC grinders : GEM DMR

Coolant: Synthetic Oil, pressure 6 bar

Control: Fanuc 31iA5

Software: Quinto 5

Accessories: Dressing, Dogdrive, Tailstock

Responsible engineer: OP. 30.4.12

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